

5/05 525

DART AEROSPACE LTD.	Work Order :	22105
Description: Cross Beam	Part Number:	D2764
Drawing: D2764 Rev. D	Qty:	4

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open Work Order *** RUN D2796 WITH SAME PROG. ***	HA	04.12.14	4
2	METAL	Cut Blanks: 48.5" Material: 1" X 2.5" 6061-T6 (QQ-A-200/8) Batch No: 115816	J.L	05.08.31	4
3	HAAS	Machine per Folio D2764	AD/JL	05/09/02	4
4	METAL	Deburr	gml	05/09/08	4
5	QC	Inspect Level 2	BG	05.09.06	4
6	METAL	Acid Etch and Alodine per QSI 005 4.1	ml	05 09 12	4
7	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	EC	05 09 23	4
8	QC	Inspect Level 3	ml	05 09 23	4
9	STORES	Identify and stock	CL	05/09/26	4
10	EXPEDITING	Close Work Order Cost / part 97.76 sub 05/09/29 (4)	HA	05/09/27	4

Rev	Date	Change	Revised By	Approved
A	98.11.02	New Issue	KS	
B	98.11.24	Dwg to Rev. D	DM	
C	00.07.06	Removed P/O for powder coat, and reformed	EC	
D	00.08.14	Added note at step #1	EC	

RELEASED

EC 00.08.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

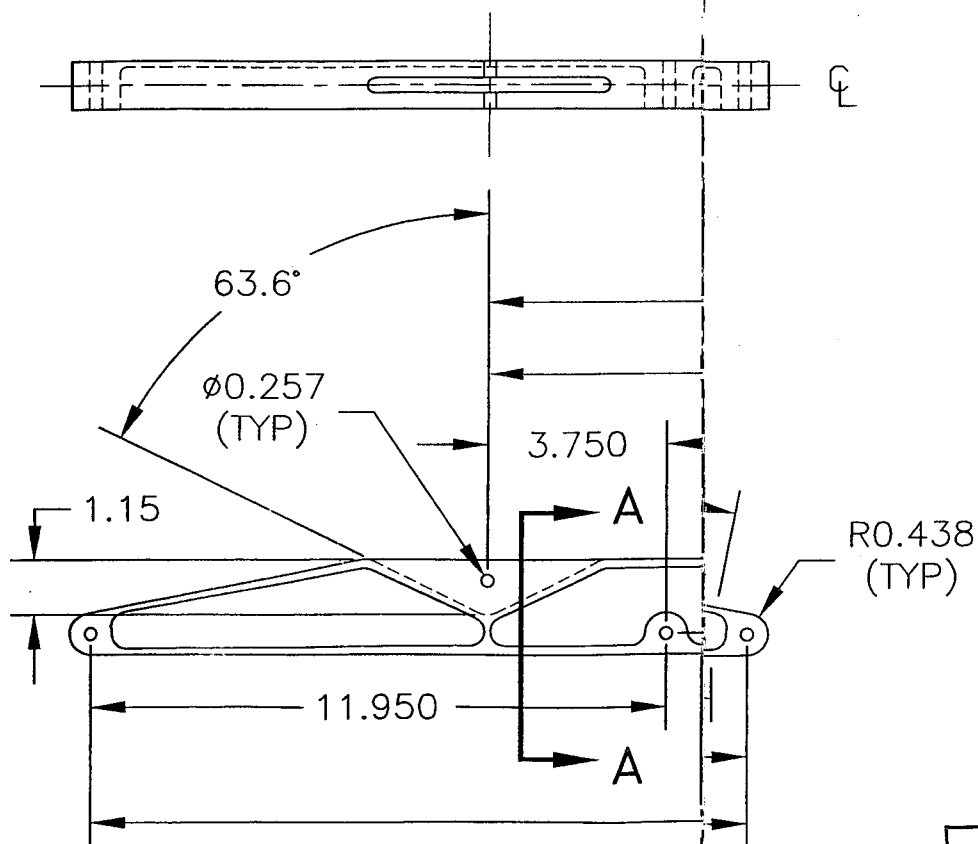
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DS Date: 05/09/27

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

0.312

R0.125 (REF)
0.125SEC
SC

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22105

RELEASED
98.11.18 KE

EFFECTIVE DEOs

9126	



MATERIAL: 6061-T
FINISH: ACID ETCH
POWDER
TOLERANCES PER

1 TAPERED WAL

98.11.09	TAPERED WALLS ADDED
98.09.01	MACHINED PART WAS BOX BEAM
98.06.17	ADD LARGE HOLES & STIFFENER
98.04.14	NEW ISSUE

DRAWN BY

APPROVED

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2764

REV. D

SHEET 1 OF 1

TITLE
CROSS BEAM

SCALE

1:4

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 13, 2004
11:38 am

Work Order No : 0022105
Project Name : D2764
Project For : WK505
Work Order Type : Main
Main WO Number :
House Part Number : D2764
Description : Cross Beam
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-13-04
Est Finish Date : 02-02-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

DART AEROSPACE LTD		Work Order: 22105
Description: CROSS BEAM		Part Number: D2764
Inspection Dwg: D2764	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.312	±.010	.315"				
1.000	"	1.005				
.188	"	.192				
.125	"	.132				
R.125	"	.125				
.125	"	.131				
2.000	"	2.009				
.312	"	.315"				
1.15	±.03	1.146"				
Ø.257	+0.006 -0.001	.762				
3.750	±.010	3.750				
.438	"	.435				
15.500	"	15.500				
31.000	"	31.000				
3.750	"	3.750				
.438	"	.438				
5.02 Δ	"	✓				Thickness over indicated length
R.438	"	.438				
7.10 Δ	"	✓				"
6.96 Δ	"	✓				"
5.02 Δ	"	✓				"
47.40	±.03	47.40				
11.950	±.010	11.950				

Measured by: BG	Audited by: En	Prototype Approval:	
Date: 05.09.02	Date: 05/09/03	Date:	
Date	Change	Revised by	Approved
	New Issue	KJ/RF	